



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4273-042
Job Sheet 166567



Part No: D4273-042

Job Qty: 1 ea

Part Name: Basket Base Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/11/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG D4279 REV B SHEETS 1,2, D4273 REV F SHEETS 6,7,8,9,10 IPP Rev:A 10.11.16 new issue DD
verf:EC IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03 AS PER DWG REV.D DD
verf:EC IPP Rev:D 12.07.24 AS PER DWG REV.E DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/8/17	0.00	0.00	Start Up Large Fab2		OK 2017-10-27
100	Large Fab	1 pcs		11/9/17	0.00	31.15	Large Fab 1		C.L. 2017-10-1
110	QC	1 pcs		11/9/17	0.00	0.00	QC9		PD 17-10-02
120	QC	1 pcs		11/9/17	0.00	0.00	QC5		PD 17-11-02
125	HandFinish	1 pcs		11/9/17	0.00	0.40	HandFinish2		BR 17-11-10
130	Powdercoat	1 pcs		11/10/17	0.00	0.67	Powdercoat2		BR 17-11-10
140	QC	1 pcs		11/10/17	0.00	0.00	QC3		OK 12/11/14
150	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3		OCT 14 2017
160	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21		NOV 14 2017

Part Op 100 - 1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION N-N ON PAGE 7 DWG D4273, NEED Descriptions: TO WELDED AFTHET MESH IS INSTALL) weld as per dwg D4273 using DT9610A 2- Cut D4279-1 (MADE ON THIS W/O) base mesh and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear



S002939



Basket Base Assembly, RH

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA

TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

M138041.
STAR: 9:30
OUT: 3:35
FINISH 9:45

PART NO:

D4273-042

Revision:

Operation:

Start up Operation

Quantity:

1

Change No:

Mfg Date: 10/27/17

Job No: 166567

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581	2	18	0	0
	D3913-1	1	16	0	0
	D3913-15	1	11	0	0
	D3913-3	1	18	0	0
	D3913-9	1	1	0	0
	D3916-5	3	13	0	0
	D4016-1	3	10	0	0
	D4017-7	3	18	0	0
	D4021-1	3	30	0	0
	D4277-19	1	5	0	0
	D4277-3	1	5	0	0
	D4277-5	2	10	0	0
	D4277-9	1	5	0	0
	D4278-041	1	4	0	0
	D4278-045	2	4	0	0
	D4278-047	1	4	0	0
	D4279-5	1	6	0	0
	D4279-7	2	10	0	0
	D4279-9	1	5	0	0
	D4306-044	1	6	0	0
	D4306-045	1	6	0	0
	D4306-1	1	7	0	0
	D4672-1	2	5	0	0
	M304EX0.75-16F	32	670	0	0
Part Specifications					
Specifications could not be found.					



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Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	11/8/17	0.00	0.00	Start up container	
100	Large Fab	1 pcs	11/9/17	0.00	31.15	Large Fab 1	
110	QC	1 pcs	11/9/17	0.00	0.00	QC9	
120	QC	1 pcs	11/9/17	0.00	0.00	QC5	
125	HandFinish	1 pcs	11/9/17	0.00	0.40	HandFinish2	
130	Powdercoat	1 pcs	11/10/17	0.00	0.67	Powdercoat2	
140	QC	1 pcs	11/10/17	0.00	0.00	QC3	
150	Packaging	1 pcs	11/10/17	0.00	0.00	Packaging3	
160	QC21-SA	1 Ea	11/10/17	0.00	0.00	QC21	

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130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Large Fab	D2581	2	32	0	0
166087	D3913-1	1	2	0	0
161938	D3913-15	1	13	0	0
166088	D3913-3	1	4	0	0
5000615	D3913-9	1	1	0	0
D165912	D3916-5	3	7	0	0
159537	D4016-1	3	16	0	0
165913	D4017-7	3	24	0	0
166089	D4021-1	3	36	0	0
B164524	D4277-19	1	5	0	0
B164571	D4277-3	1	5	0	0
B163977	D4277-5	2	2	0	0
5001420	D4277-9	1	5	0	0
B164524	D4278-041	1	0	0	0
B164524	D4278-045	2	4	0	0
B164525	D4278-047	1	4	0	0
B164358	D4279-5	1	4	0	0
B154304	D4279-7	2	6	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

~~B164419~~ B164438

B164336 D4279-9 1 3 0 0

B164569 D4306-044 1 6 0 0

B164089 D4306-045 1 6 0 0

S000525 D4306-1 1 7 0 0

D4672-1 165600 2 9 0 0

M304EX0.75-16F 32 354 0 0

D4306-1

~~B164419~~

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					